

Work Order ID 72440

Monday, July 25, 2011 2:40:12 PM

Page 1

Item ID: D3909-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/25/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-25

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

C

100

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

110

0.00

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
Trim rivet to 1.185" long

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

11/8/2

11/6/2013

11/6/2013

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description*changer Place*
*171*Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *171*

0.00



Packaging

Memo

0.00

Packaging

11/8/3 8(2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/08/04**11-08-2*
Q

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Picklist Print

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Page 1

Work Order ID: 72440

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/25/2011





Required Date: 8/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	30.0000	1	2			
<div> <div>Location</div> <div>ST020</div> <div>70920</div> </div> <div> <div>Loc Qty</div> <div>30</div> <div>30</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3909-1  Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	16.0000	2	4			
<div> <div>Location</div> <div>ST090</div> <div>65627</div> <div>71002</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>1</div> <div>15</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3909-3  Fwd Lower Attach Arm		Manufactured	No			100	Each	13.0000	1	2			
<div> <div>Location</div> <div>ST081</div> <div>57819</div> <div>65628</div> </div> <div> <div>Loc Qty</div> <div>13</div> <div>1</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3909-5  Eyebolt Stud		Manufactured	No			100	Each	9.0000	1	2			
<div> <div>Location</div> <div>ST091</div> <div>65629</div> </div> <div> <div>Loc Qty</div> <div>9</div> <div>9</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

4

[Handwritten signature]

[Handwritten signature]

[Handwritten signature]

[Handwritten signature]

70920

65627 1/2
71002 1/2

65628

65629

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 72440

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 2.00

Required Qty: 2.00

D3910-1
Crosstube Lug

Manufactured No

100 Each

24.0000

2

4

Location

Loc Qty

Loc Code

ENG

22

70160

22

st507

2

68263

2

D3917-1
Washer

Manufactured No

100 Each

7.0000

2

4

Location

Loc Qty

Loc Code

ST092

7

66322

7

AN3C12A
Bolts

Purchased No

100 Each

59.0000

4

8

Location

Loc Qty

Loc Code

ST351

59

117514

4

118112

5

118422

50

AN3C13
Bolt

Purchased No

100 Each

49.0000

1

2

Location

Loc Qty

Loc Code

ST351

49

114714

49

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 72440

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 2.00

Required Qty: 2.00

MS17984-C413 Purchased No

100

Each

6.0000

1

2



PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

6

114340

1

117557

5

100

Each

88.0000

3

6

MS20615-4M20 Purchased No



RIVET

Location

Loc Qty

Loc Code

GA

88

117071

88

100

Each

47.0000

1

2

AN310C3 Purchased No



Castellated Nut

Location

Loc Qty

Loc Code

ST349

47

114714

47

100

Each

694.0000

4

8

MS21043-3 Purchased No



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

622

112314

6

118077

616

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Page 3

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Page 4

Work Order ID: 72440

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-151

Purchased

No

100

Each

443.0000

1

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

443

17566

443

100

Each

8,297.000

8

16

NAS1149C0332R

Purchased

No



Washer

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

8290

116304

55

117460

62

117887

199

118078

2

118179

86

118306

2886

118354

5000

NAS1149C0363R

Purchased

No

100

Each

4,257.000

2

4



Washer

Location

Loc Qty

Loc Code

ST297

4257

114742

4257

Monday, July 25, 2011 2:40:18 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

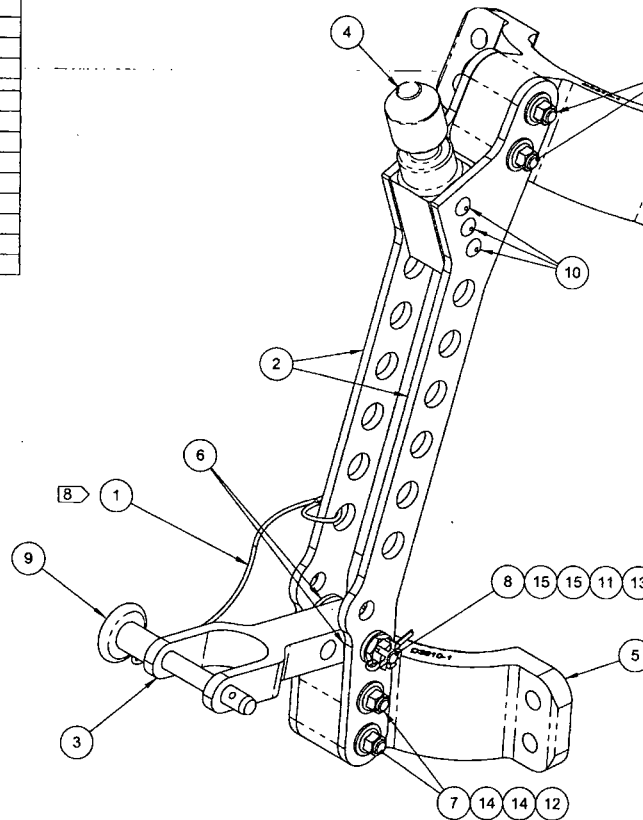
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 1.81 lbs

8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72440

11-07-25

RELEASED
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5), 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041-5).	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHY 5, D3909-5 REVISED; SECTION A-A & DIM 0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF, 1.30 WAS 1.00, 0.250 WAS 0.220. R0.06 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3909	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

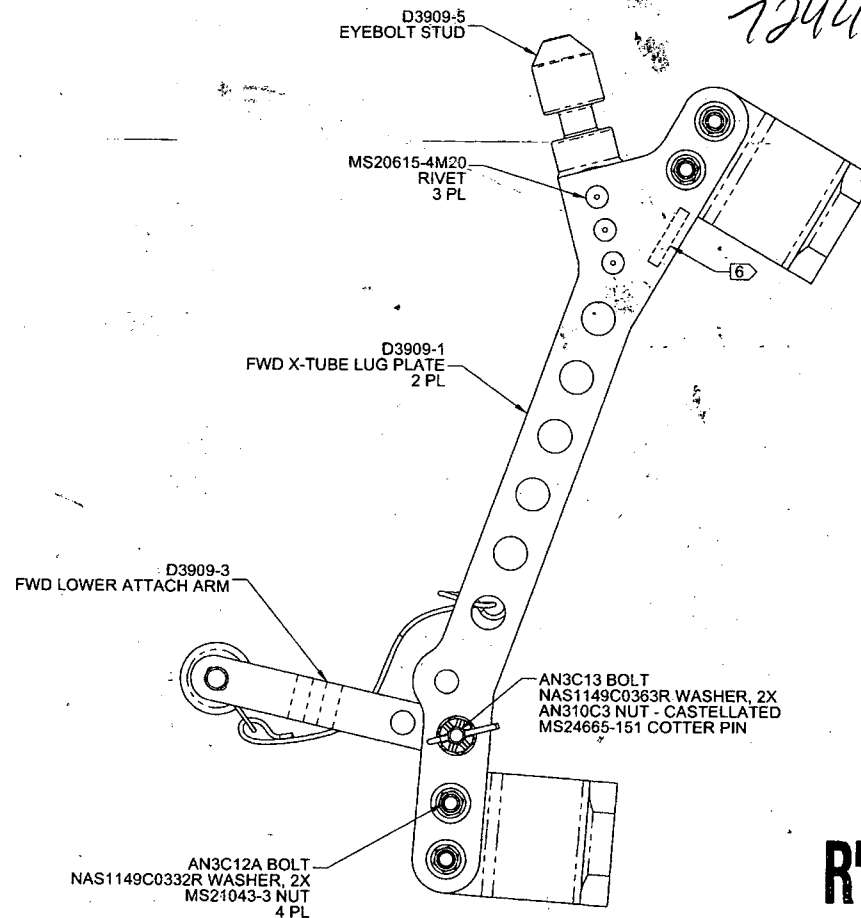
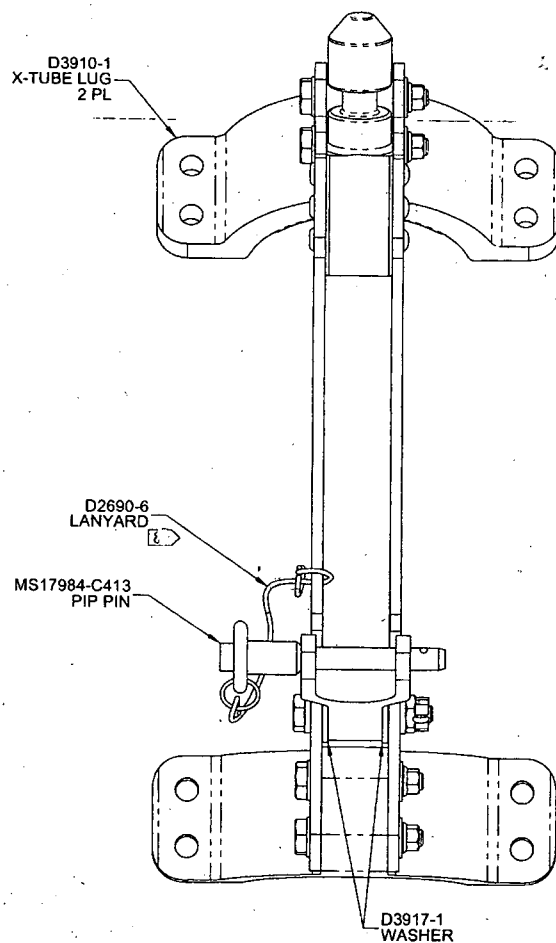
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-08-04

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 2 OF 5
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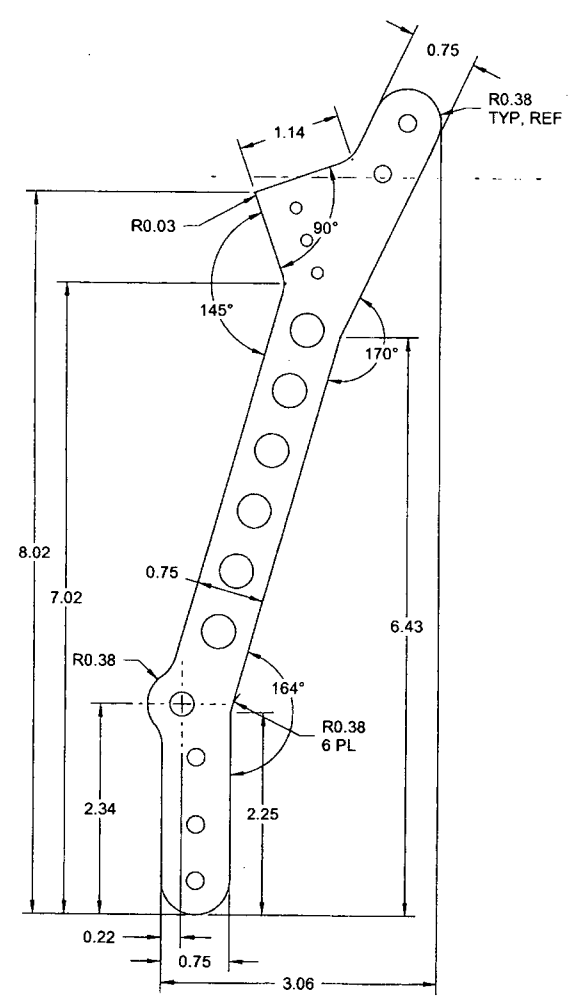
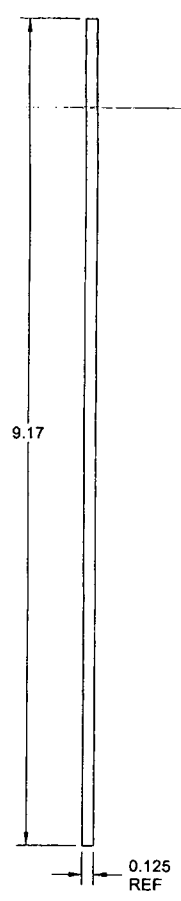
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

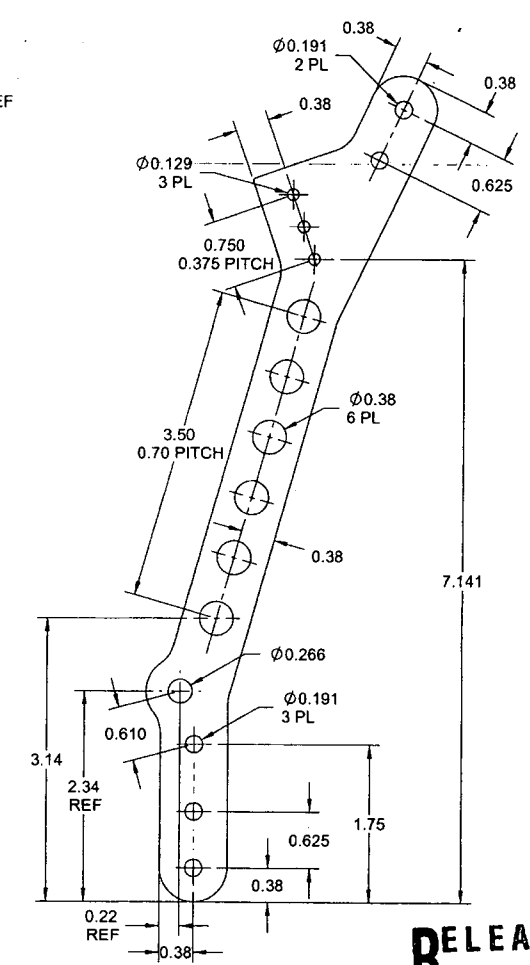
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NOTE: Date & initial all entries

72440



D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

RELEASED
2010-08-04

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.25 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD.X-TUBE LUG ASSY.	NTS
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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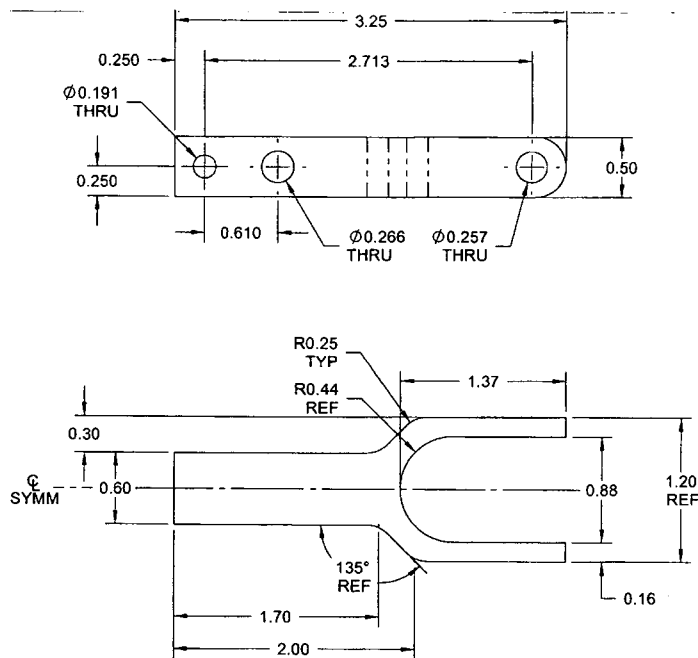
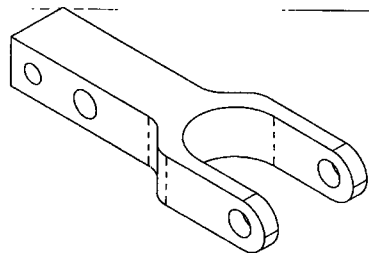
Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries



D3909-3 FWD LOWER ATTACH ARM

72440

RELEASED
2010-08-06

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 4 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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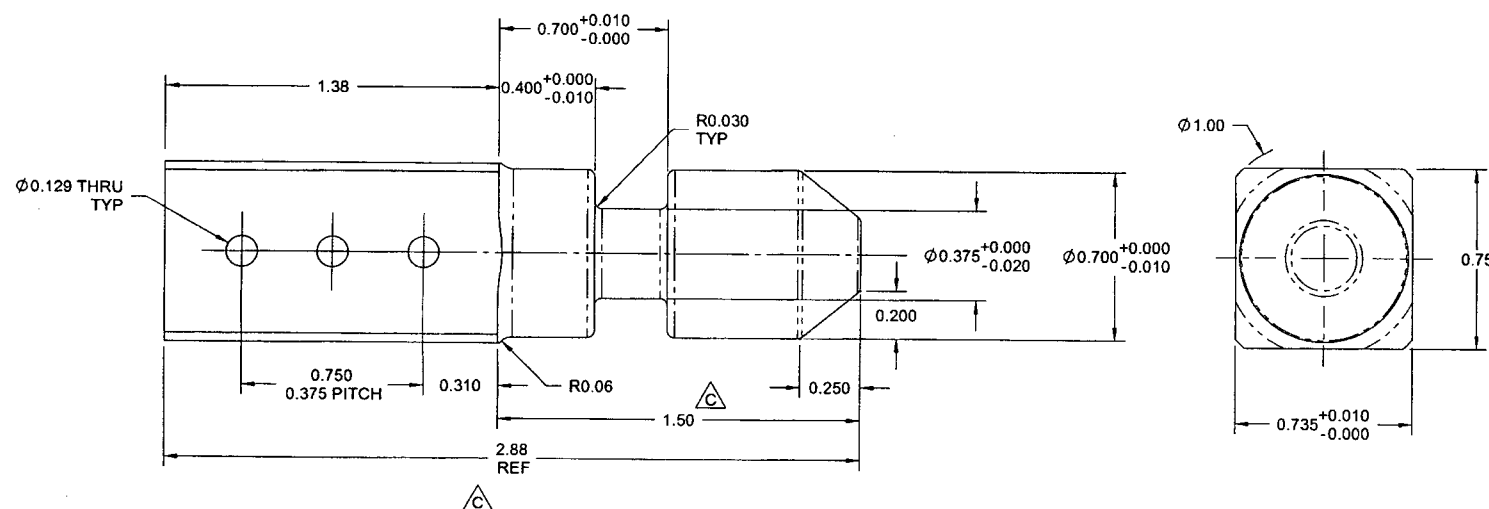
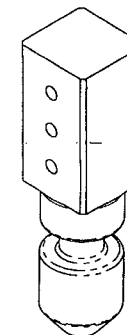
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72440



D3909-5 EYEBOLT STUD

RELEASED
2010-08-04

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276 PER DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NT
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